

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010923**Date Inspected:** 30-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector, George Goulet, proceeded to the Bay 10 in response to a ZPMC notification of witness inspection #4964 for visual inspection (VT) as follows:

This QA Inspector, George Goulet, performed random VT of the area previously tested and accepted by ZPMC Quality Control personnel. The members were identified as south tower, lift 4, skin B/C corner assemblies at single and double diaphragm flanges. This QA inspector reviewed the following welds and observed that they appeared to generally comply with applicable contract documents: SSTL4-1B/L-51, SSTL4-1B/L-52, SSTL4-1C/L-62, SSTL4-1C/L-65, SSTL4-1C/L-126, SSTL4-1C/L-127, SSTL4-1F/L-62, SSTL4-1F/L-64, SSTL4-1F/L-126, SSTL4-1G/L-57, SSTL4-1G/L-59, SSTL4-1G/L-121, SSTL4-1G/L-125. This QA Inspector noted this QA Inspector's Caltrans lot number on ZPMC paperwork indicating that the above listed welds appeared to comply with contract documents.

This QA Inspector performed random VT of fillet portion of weld SSTL4-1F/L-124 and observed the weld size of both legs to be less than 30mm reinforcement as required by the applicable contract drawings. This QA Inspector performed random VT of weld SSTL4-1H/L-57 and observed a 2.5mm excavation into skin C base metal at one end of the weld. This QA Inspector reported these two issues to ZPMC QC Inspector Jiang Xiao Bo, who observed the welds and agreed with this QA Inspector's observations.

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Note: No ABF personnel presented this QA Inspector with any green tag document during the time of this inspection or during this shift.

This QA Inspector also randomly observed the following work in progress in Bay 10:

FCAW welding of weld joints SSTL4-1D/L-11, 41 located inside PCMK south tower, lift 4, on the diagonal plates at the skin C/D corner on either side of 139M double diaphragm. Welder was identified as 040041. ZPMC QC was identified as CWI Wang Chuan Qing (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2233-B-U2a-F.

FCAW welding of weld joints SSTL4-1D/L-43, 13 located inside PCMK south tower, lift 4, on the diagonal plates at the skin C/D corner on either side of 135M double diaphragm. Welder was identified as 040343. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2233-B-U2a-F.

FCAW welding of weld joints SSTL4-1D/L-8, 45 located inside PCMK south tower, lift 4, on the diagonal plates at the skin C/D corner on either side of 135M double diaphragm. Welder was identified as 052075. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-2233-B-U2a-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Dawson, Paul	QA Reviewer
